AMENDMENTS TO THE SPECIFICATION

Please amend the specification as indicated below.

Please amend page 12, lines 11-18 as follows:

Another technique to modify the thermal insulating value of the center area is to use sheets having high thermal insulating values and/or sheets having low emissivity coatings, e.g. the coating 105 on inner surface of the sheet 12. Types of low emissivity coatings that may be used in the practice of the invention are taught in U.S. Pat. Nos. 4,610,771; 4,806,220; and 4,853,256 which teachings are hereby incorporated by reference. Also increasing the number of glass sheets increases the number of compartments thereby increasing the insulating effect at the center and edge areas of the unit.

Please amend page 28, lines 1-8 as follows:

The discussion will now be directed to the U-value of the frame of the unit. With reference to FIG. 10, there is shown a frame 300 with the unit 150 mounted in the frame 300. The frame 300 also conducts heat and in certain instances e.g. metal frames conduct sufficiently more heat than the edge assembly of the unit such that the edge heat loss through the frame overshadows any increase in thermal resistance to heat loss provided at the edge of the unit. Wooden frames, metal frames with thermal breaks or plastic frames have high resistance to heat loss and the performance of the edge heat loss of the unit would be more dominant.

Please amend the paragraph on page 30 as follows:

In the practice of the invention the metal substrate after forming into spacer stock and the bead has sufficient structural strength and resiliency to keep the sheets spaced apart and yet accommodates a certain degree of thermal expansion and contraction which typically occurs in the several component parts of the insulating glazing unit. In one embodiment of the invention the spacer is

more structurally stable than the bead i.e. the spacer is sufficiently structurally stable or dimensionally stable to maintain the sheets spaced from one another whereas the bead cannot. In another embodiment of the invention both the spacer and the bead can. For example, the bead may be a desiccant in a preferred spacer taught in U.S. Pat. No. 3,919,023 to Bowser. As can be appreciated by those skilled in the art, a metal spacer can be fabricated through a series of bends and shaped to withstand various compressive forces. The invention relating to the bead 160 carried on the substrate 170 is defined by shaping the substrate 170 into a single walled U-shaped spacer stock with the resultant U-shaped spacer stock being capable of withstanding values of compressive force to maintain the sheets apart regardless of the structural stability of the bead. As can be appreciated by those skilled in the art the measure and value of compressive forces and structural stability varies depending on the use of the unit. For example if the unit is secured in position by clamping the edges of the unit such as in curtainwall systems, the spacer has to have sufficient strength to maintain the glass sheet apart while under compressive forces of the clamping action. When the use is mounted in a rabbet ~~rabbit~~ of a wooden frame and caulking applied to seal the unit in place, the spacer does need as much structural stability to maintain the glass sheets apart as does a spacer of a unit that is clamped in position.

Please amend page 31, lines 16-19 as follows:

With reference to FIG. 16, the lower wheel 202 of the roll forming station 185 has a peripheral groove 203 ~~202~~ that is substantially U-shaped. The spacer stock exiting the roll forming station 185 is the U-shaped spacer 158 shown in FIG. 10.

Please amend page 33, lines 13-24 as follows:

With reference to FIG. 19, in the practice of the invention spacer frame 240 was formed from a U-shaped spacer stock. A continuous corner 242 was formed by depressing the outer legs of the spacer stock toward one another

while bending portions of the spacer stock about the depression to form a corner e.g. 90° angle. As the portions of the spacer stock are bent the depressed portions 244 of the outer legs move inwardly toward one another. After spacer frame was formed, layers of the sealant were provided on the outer surface of the legs 156 ~~18~~ of the spacer frame and the bead 26 on the inner surface of the middle leg of the spacer frame. The unit 10 was assembled by positioning and adhering the glass sheets to the spacer frame by the sealant layers 154 in any convenient manner.